

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015195**Date Inspected:** 29-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 4E/5E Welds D1 & D2, Face B
- 2). OBG Field Splice 1W/2W Welds D1 & D2, Face B
- 3). OBG Field Splice 4W/5W Weld F, Face A

- 1). OBG Field Splice 4E/5E weld ID: D1 & D2, Face B

The QAI periodically observed ABF personnel performing Plasma Cutting to remove the backing bar and subsequent grinding to prepare the groove for back welding. The work at this location was in process for the remainder of the QA Inspectors shift.

- 2). OBG Field Splice 1W/2W weld ID: D, Face B

The QAI observed that this weld location is partially welded although no welding is being performed on this date.

- 3). OBG Field Splice 4W/5W weld ID: F, Face A

The QAI periodically observed the in process welding of OBG Field Splice 4W/5W weld ID: F, Face A per the Flux Cored Welding (FCAW-G) process in the 3G (vertical) position by ABF welding personnel Xiao Jian Wan (ID 9677). QC Inspector Bonafacio Daquinag was present to monitor the progress and verify that the joint fit-up & welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3040B-3. The QAI observed that the fit-up, completed root pass & welding

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parameters appeared to be in general compliance with the contract documents. When welding at this location was finished the weld was not complete. Approximately 30mm of splice weld at the intersection with plate E was left unwelded pending welding of the splice weld in plate E.

Summary of Conversations:

None of relevance.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

Inspected By:	Madison,Bert	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
